

79108

Friday, January 20, 2012 9:27:14 AM

N900040100

Setup Start *NS1*

Stop *NS2*


Start Date: 1/20/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 1/27/2012 **Req'd Qty:** 4.00 ***A***

Customer:

Reference:

Approvals: Process Plan:  Date: 12-01-20

Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

**Insp.
Stamp**

0.00

100

100

BAND SAW

0,00

Bandsaw

Jeaspa Bandsaw

Memo

Cut blank: (0.75" x 1.50") x 34.750" long Bar

0.00

110

110

HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

HAAS CNC vertical machine #1

Memo

1-Machine D3196-4 as per Folio FA339 and Dwg D3196Identify as D3196-42-
Deburr

0.00

120

120

QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Quality Control

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Item ID: D3196-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 1/20/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

3200F

11:00

m118489

OK 12/01/26

4X Ø M 12/01/26

4X Ø M 12/01/26

Work Order ID 79108

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Friday, January 20, 2012 9:27:14 AM

Item ID: D3196-4 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bar
 Start Date: 1/20/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 1/27/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>260</u> Memo	0.00 0.00							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

4 x d 12/10/26
count

12/1/26 (4)

12/1/30

12-01-27

Picklist Print

Friday, January 20, 2012 9:27:13 AM

Page 1

Work Order ID: 79108

Parent Item: D3196-4

Parent Item Name: Bar

Start Date: 1/20/2012

Required Date: 1/27/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X01.500		Purchased	No			100	f	16.0860	2.89	12.168421			

6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT002

16.086

116604

1.5

118182

2

118844

0.786

119513

11.8

20 12-1-25

2.895

2.895'

5.791'

11.581'

6061-T6 BAR .75 X 2.0

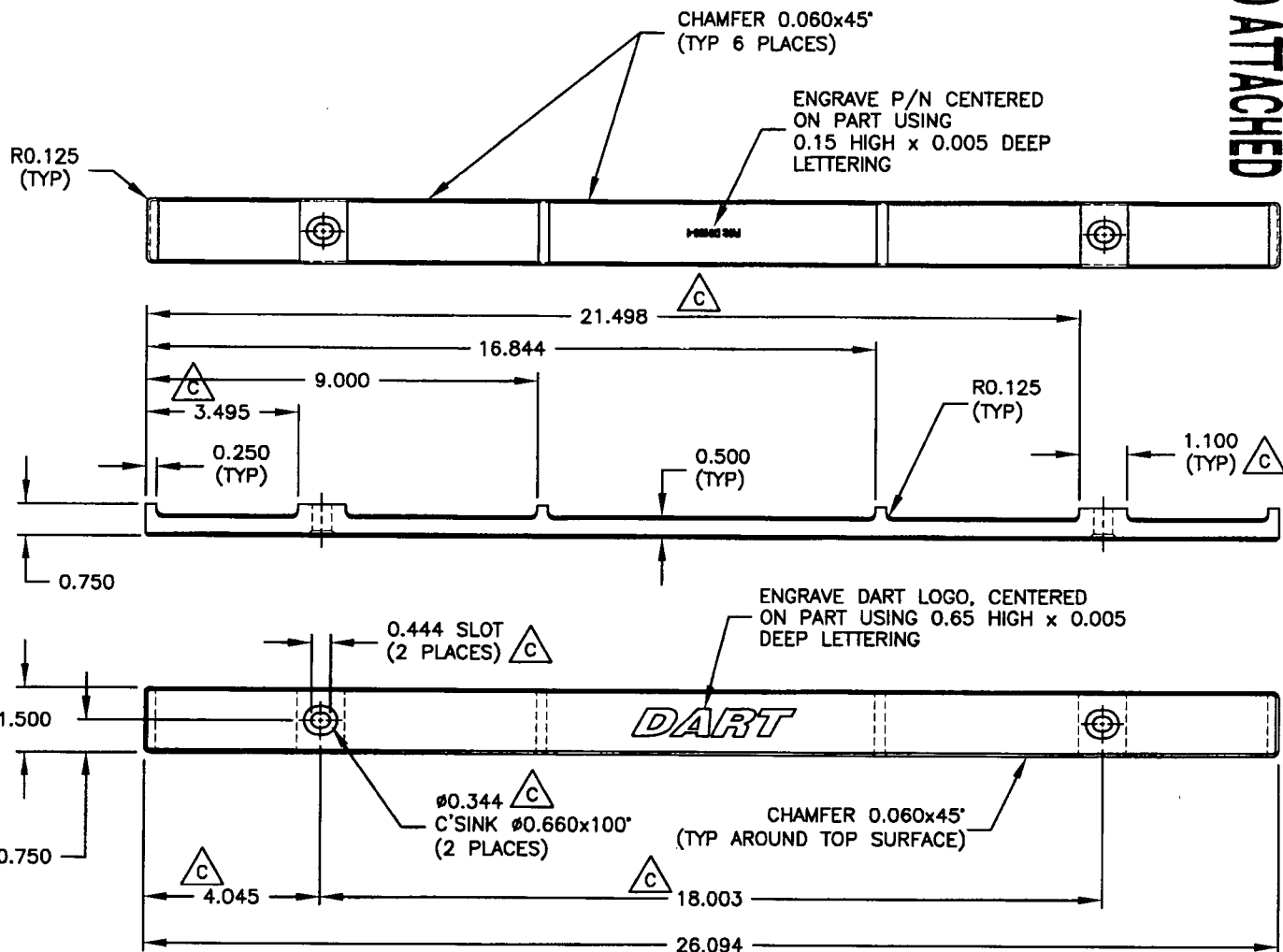
111448
119653

DART

RELEASED

06.10.31

DEO ATTACHED



D3196-1 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

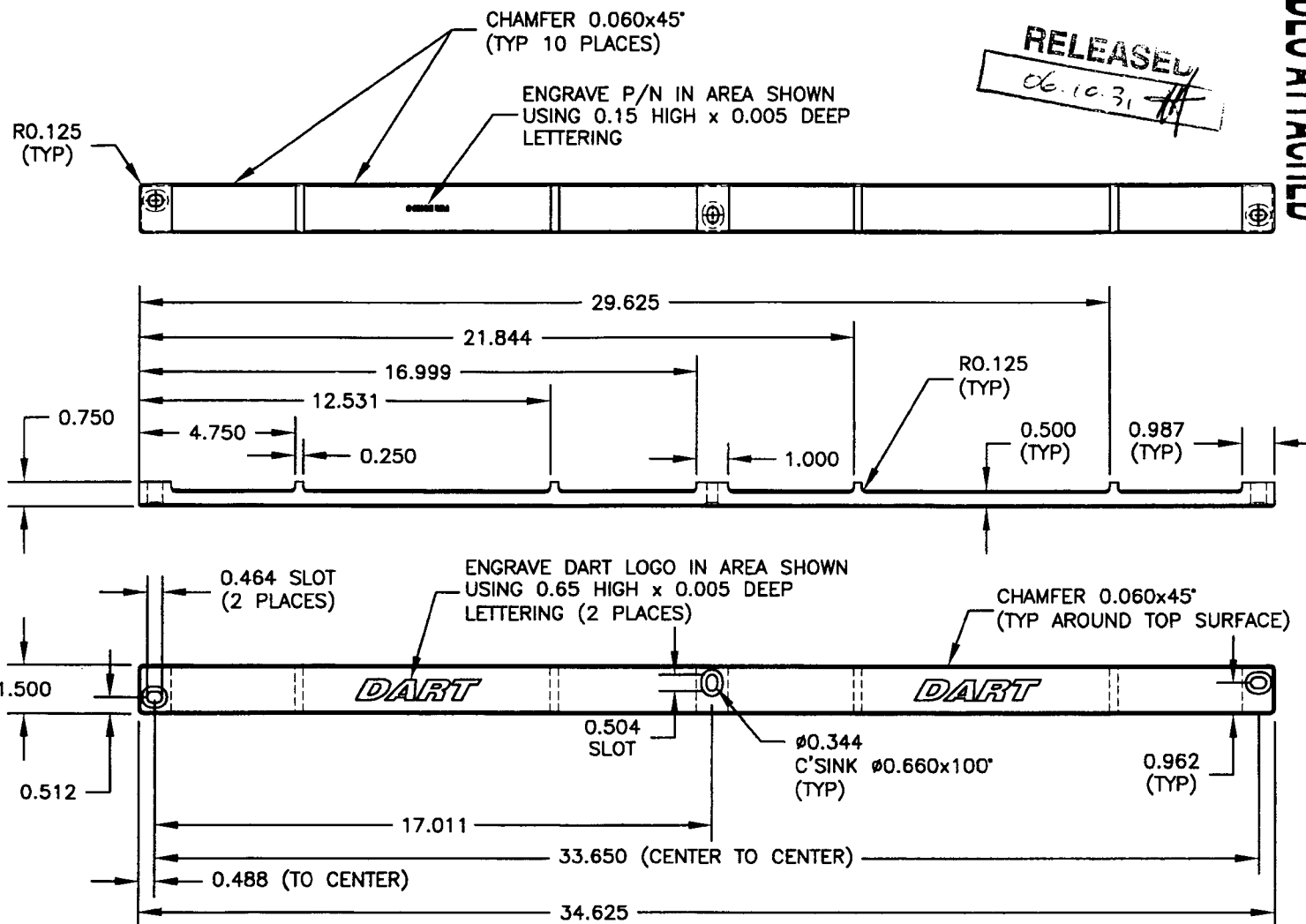
DESIGN	DRAWN BY	DART AEROSPACE LTD
Q		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
PH		D3196
DATE	TITLE	SHEET 1 OF 3
06.10.31	BAR	SCALE
		1:4
A	03.06.25	NEW ISSUE
B	06.09.25	ADD D3196-5
C	06.10.31	ADD SLOTS ON -1; REMOVED -5

#79108

DART

DETACHED

RELEASED
06.10.31



D3196-3 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8) (REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

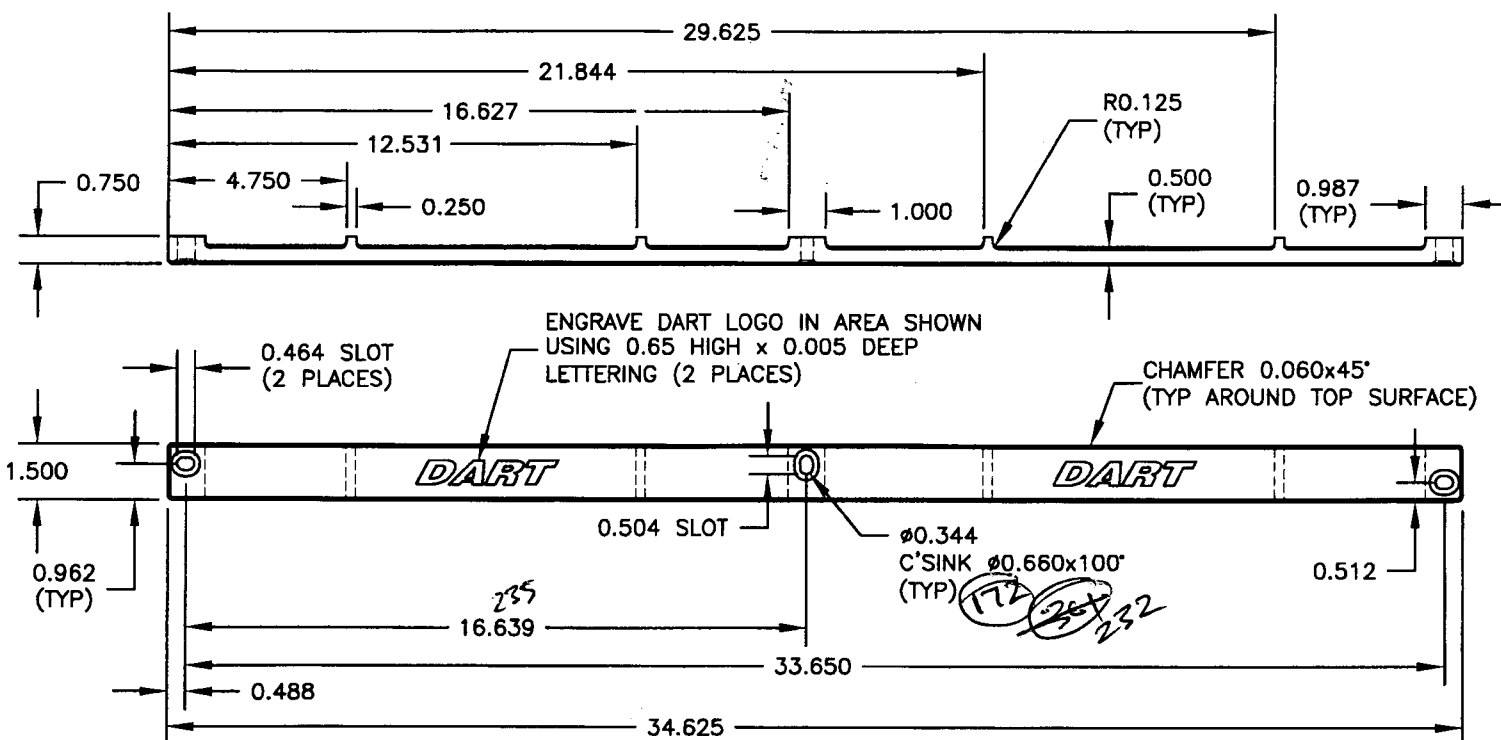
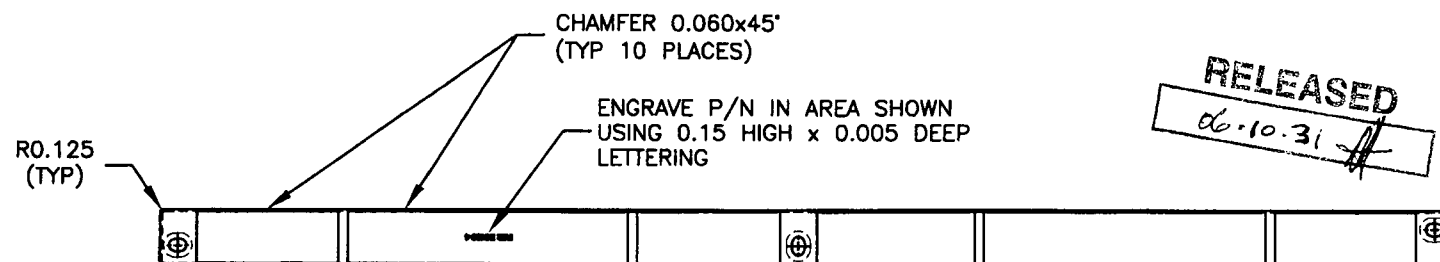
7108

DESIGN	90	DRAWN BY	JS	DART AEROSPACE LTD
CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	TITLE	BAR	REV. C
		DRAWING NO.	D3196	SHEET 2 OF 3
		SCALE	1:5	

DART

DEO ATTACHED

RELEASED
06-10-31



DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	PH	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.10.31	DRAWING NO.	D3196	REV. C
		TITLE	BAR	SHEET 3 OF 3
		SCALE	1:5	

D3196-4 BAR

- 1) MATERIAL: 6061-T6/T651 ALUMINUM (QQ-A-200/8 OR QQ-A-225/8)
(REF DART SPEC. M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D3196-C-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>		
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04		

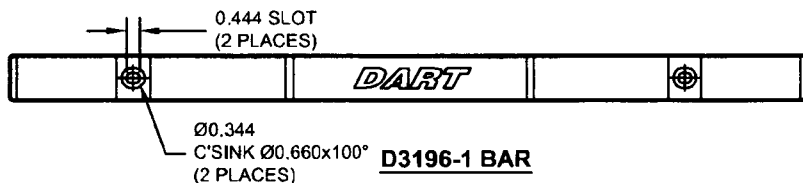
SHEET 1 MODIFY SLOT DIMENSIONING ON D3196-1 AS SHOWN:

IS:



D3196-1 BAR

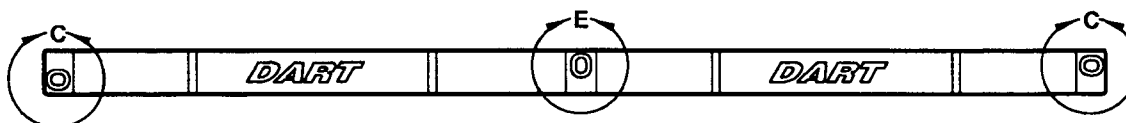
WAS:



D3196-1 BAR

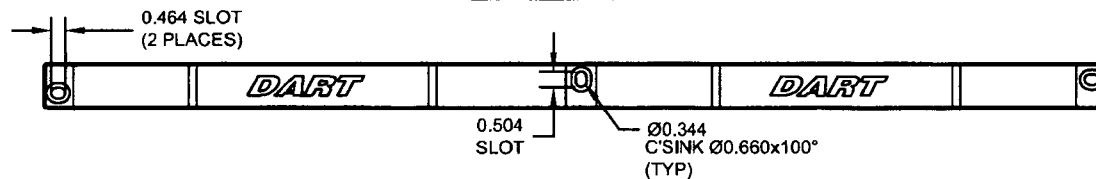
SHEET 2 MODIFY SLOT DIMENSIONING ON D3196-3 AS SHOWN:

IS:



D3196-3 BAR

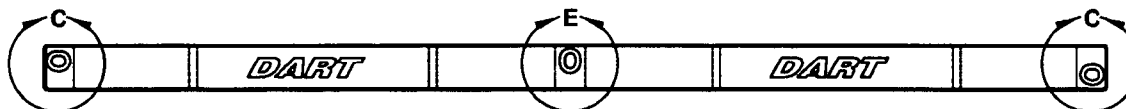
WAS:



D3196-3 BAR

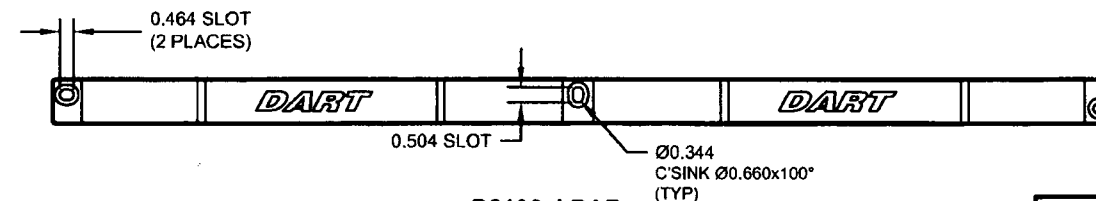
SHEET 3 MODIFY SLOT DIMENSIONING ON D3196-4 AS SHOWN:

IS:



D3196-4 BAR

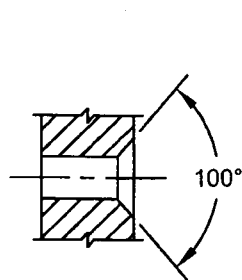
WAS:



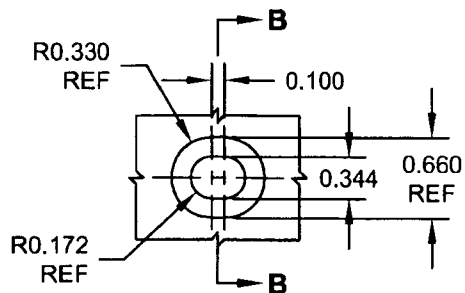
D3196-4 BAR

79108

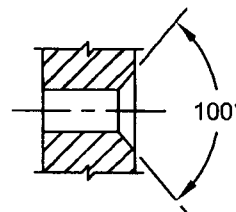
DRAWING NO. D3196	TITLE BAR	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3196-C-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN <i>ASS</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DE APPR. <i>[Signature]</i>			
DATE 08.08.27	DATE 08.08.28	DATE 08.08.29	DATE 08.08.29	DATE 08.08.29	DATE 08.09.04		



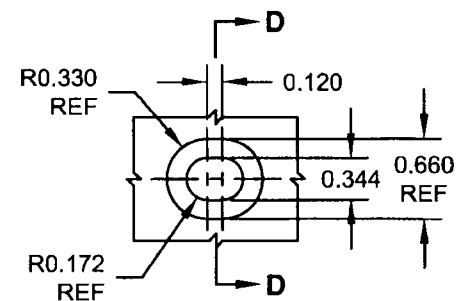
SECTION B-B



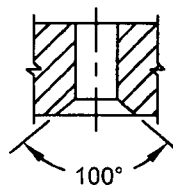
DETAIL A



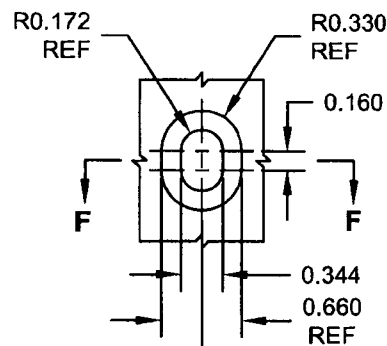
SECTION D-D



DETAIL C



SECTION F-F



DETAIL E

\$79108

NOTE: THIS CHANGE HAS BEEN DONE TO CLARIFY SLOT DIMENSIONS ONLY. NO CHANGES HAVE BEEN MADE TO THE PARTS
SEE NCR 08-051 FOR FURTHER INFORMATION
ALL OTHER INFORMATION REMAINS UNCHANGED

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DART AEROSPACE LTD		Work Order: 29108
Description: Bar		Part Number: D3196-4
Inspection Dwg: D3196	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
34.625	+/-0.010	34.626	/		Rq. 02	
33.650	+/-0.010	33.646	/			
16.639	+/-0.010	16.639	/			
0.488	+/-0.010	.489	/			
0.962	+/-0.005	.960	/			
0.464	+/-0.010	.464	/			
0.504	+/-0.010	.504	/			
Ø0.344	+0.006/-0.001	.344	/			
Ø0.660 x 100°	+0.008/-0.001 x 0.5°	.660	/			
0.512	+/-0.005	.509	/			
0.060 x 45°	+/-0.010 x 0.5°	.065	/			
4.750	+/-0.010	4.750	/			
12.531	+/-0.010	12.531	/			
16.627	+/-0.010	16.626	/			
21.844	+/-0.010	21.844	/			
29.625	+/-0.010	29.625	/			
0.250	+/-0.010	.250	/			
1.000	+/-0.010	1.000	/			
R0.125	+/-0.010	R.125	/			
0.987	+/-0.010	.987	/			

Measured by: RQ	Audited by: [Signature]	Preliminary Approval:
Date: 12.1.25	Date: 12/01/26	Date:

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.10.24	Dwg Rev updated	KJ/JLM	
C	11.06.21	Dwg Rev updated	KJ	[Signature]